



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW109-3101-58-2-PO

Job Sheet 185353



Part No: RBW109-3101-58-2-PO

Job Qty: 2 ea

Part Name: Hammer, Aluminum, Blade Corrosion & Voids Detection



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/25/18

Job Tracking No:

Due Date: 12/17/18

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBW109-3101-58-2 Rev.3 IPP Rev. A 18.10.23 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	2 pcs	12/17/18	12/17/18	0.00	0.00	Purchasing		DEC 18 2018
110	Packaging	2 pcs	12/17/18	12/17/18	0.00	0.00	Packaging2		DEC 18 2018
120	QC	2 pcs	12/17/18	12/17/18	0.00	0.00	QC6		38
130	Packaging	2 pcs	12/17/18	12/17/18	0.00	0.00	Packaging3		DEC 19 2018
140	QC21-FG	2 Ea	12/17/18	12/17/18	0.00	0.00	QC21		21

Part Op 100 - Issue P/O: 041367 MANUFACTURE RBW109-3101-58-2 AS PER DWG Supplier: METEC Certificate of Descriptions: conformity is required

Al

GA102

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW109-3101-58-2P	Hammer, Aluminum, Blade Corrosion and Voids Detection	2 pcs (1 ea)	100-Purchasing	5138613

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW109-3101-58-2P	2	0	0

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: \$138616



Part: RBW109-3101-58-2

Job No: 185353

Serial No/Batch: \$138616

Revision: 3

Inspector:

Exp Date:

Instructions:

Date: 12/19/18

Plex 10/25/18 11:38 AM dart.Lussier.Patrick

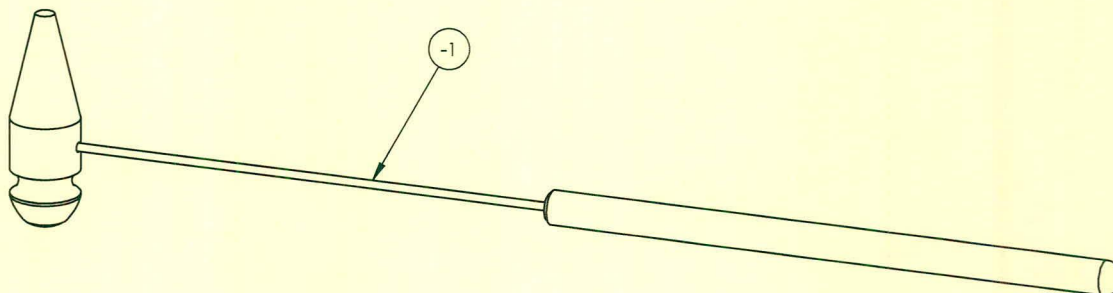
DEC 19 2010
DEC 19 2010

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1000
1000

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	6/1/2015	DPD	JAG
2	16-0246	UPDATED TO NEW STANDARDS. -1 CH'D SHEET TOLERANCE WAS $\pm .005/\pm .01/\pm .1$ IS $\pm .010/\pm .03/\pm .1$. -5 CH'D DIM WAS $(\phi .059)$ IS $(\phi .060/.058)$. -7 CH'D DIM WAS $\phi .24$ IS $\phi .25$; CH'D FINISH WAS GRAY ANODIZE IS CLEAR ANODIZE; ADDED S/N, "MADE IN USA" TO NOTE.	12/2/2016	SM	JAG
3	17-0052	-7 CH'D NOTE WAS LASER ENGRAVE T/N, S/N, "MADE IN USA" IS LASER ENGRAVE T/N.	2/20/2017	RJC	JAG

TEO ATTACHED



NOTES:

1. REF. AGUSTA T/N: 109-3101-58-2
2. -1 USED IN KITS: RBT18025, RBEA62309, RBT18510, & RBT18561.

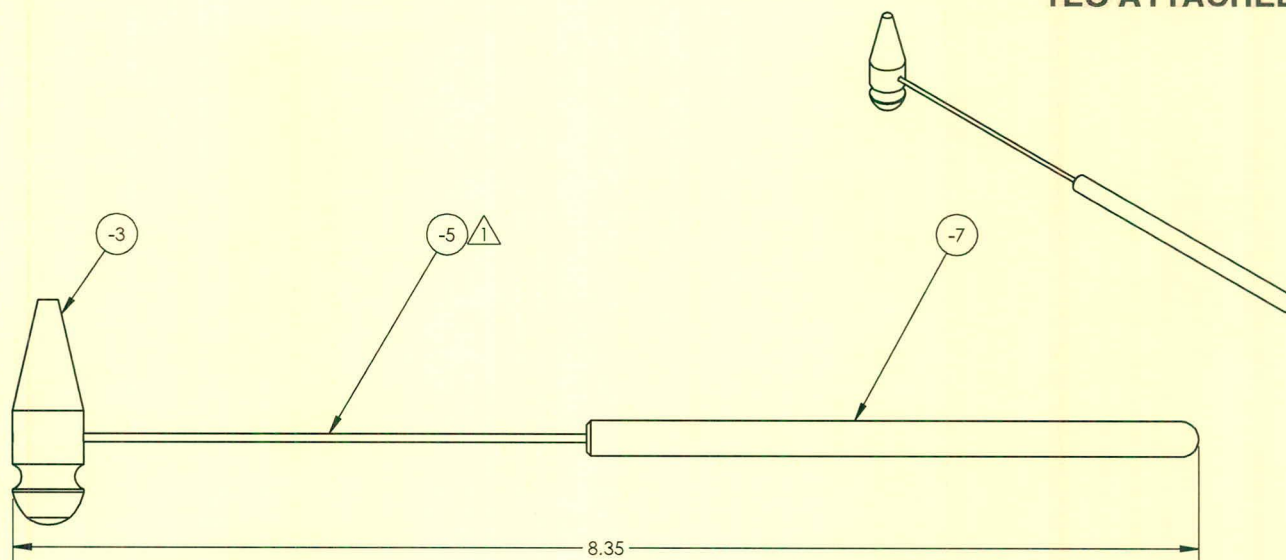
DART AEROSPACE	
TITLE HAMMER, ALUMINUM, BLADE CORROSION AND VOIDS DETECTION	
DWG NO. RBW109-3101-58-2	REV 3
MAT'L REAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS $\pm 1/8$ ANGLES $\pm 5^\circ$ SURFACES = 125/ $\sqrt{\text{ }}$ 1. BREAK ALL SHARP EDGES D15 x 45° OR D15R
DRAWN BY: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: DUERFELDT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL AW109/AW119
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:1	DATE 3/12/2015
SHEET 1 OF 5	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	1	HAMMER, ALUMINUM			2
	1		-3		HAMMER HEAD	6061		3
	1		-5		SHAFT	S.S.	$\phi .059$ X 1 FT. (MCMMASTER-CARR #8908K62) MODIFIED	4
	1		-7		HANDLE	6061		5
		B/O	-9	1	CASE	PLASTIC	SMALL PISTOL CASE RSR GROUP #10137	N/S
	ASSY -1							

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REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				
2	16-0246	-1 CH'D SHEET TOLERANCE WAS $\pm .005/\pm .01/\pm .1$ IS $\pm .010/\pm .03/\pm .1$.			12/2/2016	SM JAG

TEO ATTACHED



NOTES:

- 1 EPOXY -5 SHAFT INTO -3 HAMMER HEAD & -7 HANDLE.

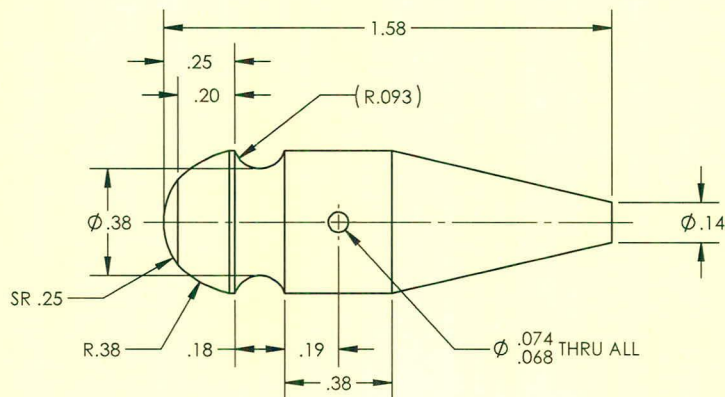
(-1)
HAMMER, ALUMINUM

DART AEROSPACE	
TITLE HAMMER, ALUMINUM, BLADE CORROSION AND VOIDS DETECTION	
DWG NO. RBW109-3101-58-2-1	REV 3
MAT'L	UNLESS OTHERWISE SPECIFIED
HEAT	DIMENSIONS ARE IN INCHES
TREAT	.XXX $\pm .010$ FRACTIONS $\pm 1/8$
FINISH	.XX $\pm .03$ ANGLES $\pm 1^\circ$
SPEC	.X $\pm .1$ SURFACES = 125 ☒
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	AW109/AW119
SCALE 1:1	DATE 3/12/2015 SHEET 2 OF 5

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REVISIONS			
REV	ECR	DESCRIPTION	DATE INITIAL APPROVED

TEO ATTACHED



(-3)

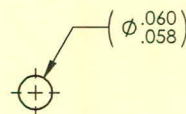
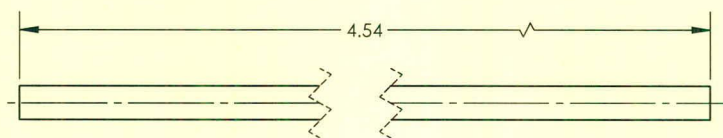
HAMMER HEAD

DART AEROSPACE	
TITLE HAMMER, ALUMINUM, BLADE CORROSION AND VOIDS DETECTION	
DWG NO. RBW109-3101-58-2-3	REV 3
MAT'L 6061	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH CLEAR ANODIZE	.XXX $\pm .005$ FRACTIONS $\pm 1/8$
SPEC MIL-A-8625F, TYPE II, CLASS I	.XX $\pm .01$ ANGLES $\pm 5^\circ$
DRAWN BY: DUERFELDT	.X $\pm .1$ SURFACES = 125 $\checkmark$
CHECKED: DUERFELDT	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2003
SCALE 2:1	USED ON MODEL
DATE 3/12/2015	AW109/AW119
SHEET 3 OF 5	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0246	-5 CH'D DIM WAS (Ø.059) IS (Ø.060/.058)	12/2/2016	SM	JAG

TEO ATTACHED



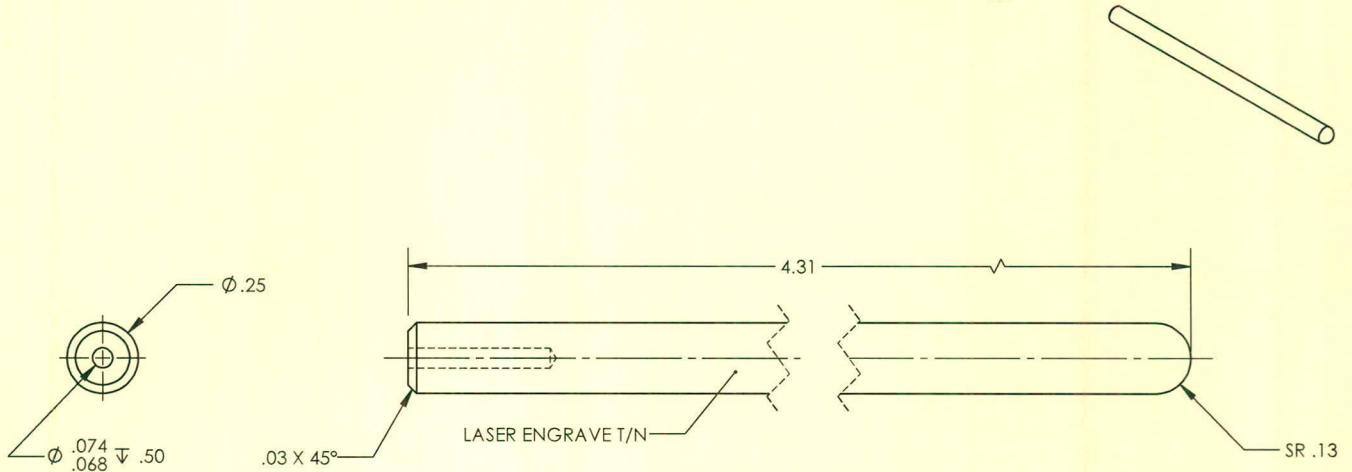
(-5)
SHAFT

DART AEROSPACE	
TITLE HAMMER, ALUMINUM, BLADE CORROSION AND VOIDS DETECTION	
DWG NO. RBW109-3101-58-2-5	REV 3
MAT'L S.S.	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125/✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
	USED ON MODEL
	AW109/AW119
SCALE 4:1	DATE 3/12/2015
	SHEET 4 OF 5

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
2	16-0246	-7 CH'D DIM WAS Ø.24 IS Ø.25; CH'D FINISH WAS GRAY ANODIZE IS CLEAR ANODIZE; ADDED S/N, "MADE IN USA" TO NOTE.	12/2/2016	SM
3	17-0052	-7 CH'D NOTE WAS LASER ENGRAVE T/N, S/N, "MADE IN USA" IS LASER ENGRAVE T/N.	2/20/2017	RJC
APPROVED			JAG	

TEO ATTACHED



(-7)
HANDLE

DART AEROSPACE	
TITLE HAMMER, ALUMINUM, BLADE CORROSION AND VOIDS DETECTION	
DWG NO. RBW109-3101-58-2-7	REV 3
MAT'L 6061	UNLESS OTHERWISE SPECIFIED
TREAT	DIMENSIONS ARE IN INCHES
FINISH CLEAR ANODIZE	.XX ± .005 FRACTIONS ± 1/8
SPEC MIL-A-8625F, TYPE II, CLASS I	.XX ± .01 ANGLES ± 5°
DRAWN BY: DUERFELDT	.X ± .1 SURFACES = 125
CHECKED: DUERFELDT	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 X 45° OR .016
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	AW109/AW119
SCALE 2:1	DATE 3/12/2015
	SHEET 5 OF 5

**ENGINEERING ORDER # TEO17-641**

SCALE: NTS

SHEET 1 OF 1

DRAWING NO. RBW109-3101-58-2

REV: 3

EFF.: NEXT ORDER

CHANGE CATEGORY

TITLE: HAMMER, ALUMINIUM, BLADE CORROSION AND VOIDS DETECTION

☐ MAJOR ☒ MINOR

DATE 17.09.07

APPROVED: WM 10/09/2017

MFG: APPR.: DP 09/27/2017

CHECKED: SAC 09/26/2017

DRAWN: VM 09/26/2017

TRANSACTION CODE (TC):

A-ADD

C-CREATE

R-REVISE

D-DELETE

REASON: EPOXY DETAILS MISSING

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WAS : PART# RBW109-3101-58-2-1 CALLED : EPOXY (IN NOTES)

IS : PART# RBW109-3101-58-2-1 CALLED : LOCTITE CLEAR MULTIPURPOSE EPOXY

DOCUMENTS EFFECTED: ☐ PATTERN ☐ INSTALL INSTRUCTIONS ☒ BOM



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041367**

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041367

PO Date: 10/16/18

Due Date: 12/17/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Revised

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	185295	RBW6005G01631-3GP			Dial Indicator Swash Plate Scissors Support REV A	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$1,150.00/pcs	\$2,300.00
Line Item Note SIOP													
2	185392	RBW1205G00231-3GP			Main Rotor Damper Oil Filling Adapter REV 2B	Firmed	-	12/17/18	3 pcs	0 pcs	3 pcs	\$1,000.00/pcs	\$3,000.00
Line Item Note SIOP													
3	185298	RBW6405G00332-3GP			Tail Rotor Pitch Control Adjustment Tool REV 5	Firmed	-	12/17/18	1 pcs	0 pcs	1 pcs	\$1,500.00/pcs	\$1,500.00
Line Item Note SIOP													
4	185299	RBW6005G01531-3GP			Dial Indicator Main Rotor Damper Support REV 2	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$900.00/pcs	\$1,800.00
Line Item Note SIOP													
5	185300	RBW6405G00531-3GP			Tail Rotor Damper Length Adjustment Tool REV A	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$700.00/pcs	\$1,400.00
Line Item Note SIOP													
6	185301	RBW6405G02131-3GP			Tail Rotor Blade Damper Attachment Bushing Removal REV D	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$500.00/pcs	\$1,000.00
Line Item Note SIOP													
7	185302	RBW6205G05951-3GP			RBW6205G05951-3GP REV 2	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$450.00/pcs	\$900.00
Line Item Note SIOP													



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041367**

Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
18		RBW6405G08732-3GP			Tail Rotor Bushing Removal Tool RBW6405G08732-3G Rev. E	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$875.00/Ea	\$875.00
Line Item Note SUB ASSY FOR RBW6405G08632-3G													
19	185430	RBW6205G10451-3GP			Threaded Rod	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$208.33/Ea	\$208.33
Line Item Note SUB ASSY FOR RBW6205G08931-3G													
20	185431	RBW6205G10551-3GP			Hammer	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$208.33/Ea	\$208.33
Line Item Note SUB ASSY FOR RBW6205G08931-3G													
21	185432	RBW6205G10351-3GP			Guide REV 1	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$208.33/Ea	\$208.33
Line Item Note SUB ASSY FOR RBW6205G08931-3G													
22	185433	RBW6205G10251-3GP			Threaded Rod	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$208.33/Ea	\$208.33
Line Item Note SUB ASSY FOR RBW6205G08931-3G													
23	185434	RBW6205G10151-3GP			Pusher REV 1	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$208.33/Ea	\$208.33
Line Item Note SUB ASSY FOR RBW6205G08931-3G													
24	185435	RBW6205G10651-3GP			Stop	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$208.33/Ea	\$208.33
Line Item Note SUB ASSY FOR RBW6205G08931-3G													
25	185461	RBW6305G26631-3G-1P			Pin REV 2	Firmed	-	12/17/18	8 Ea	0 Ea	8 Ea	\$56.25/Ea	\$450.00
Line Item Note SUB ASSY FOR RBW6305G26631-3G													
26	185462	RBW6305G26631-3G-3P			Handle REV 2	Firmed	-	12/17/18	8 Ea	0 Ea	8 Ea	\$56.25/Ea	\$450.00
Line Item Note SUB ASSY FOR RBW6305G26631-3G													
Grand Total:												\$23,959.98	

Order Notes

Procurement Quality Clauses

A005 RIGHT OF ENTRY
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041367**

Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	185303	RBW3205G00151-3GP			Main Landing Gear R&R Wrench REV 2	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$400.00/pcs	\$800.00
Line Item Note SIOP ORDER 7393 22 Jan 2019													
9	185349	RBW6205G26631-3GP			Wrench, MR Scissor Retaining Nut Removal/Install REV 2	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$280.00/pcs	\$560.00
Line Item Note SIOP													
10	185352	RBW6205G26551-3GP			Main Rotor Scissor Locknut REV B	Firmed	-	12/17/18	2 Ea	0 Ea	2 Ea	\$175.00/Ea	\$350.00
Line Item Note SIOP 2X DEC 17 2018													
11	185353	RBW109-3101-58-2P			Hammer, Aluminum, Blade Corrosion and Voids Detection REV 3	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$150.00/pcs	\$300.00
Line Item Note SIOP 2X DEC 18 2018 DAS 38 9-89													
12	185354	RBW109-3101-58-1P			Hammer, Steel, Blade Corrosion and Voids Detection REV 3	Firmed	-	12/17/18	1 pcs	0 pcs	1 pcs	\$150.00/pcs	\$150.00
Line Item Note SIOP 1 X DEC 18 2018													
13	185406	RBW6205G03451-3GP			Bolt Guide Removal & Install REV 2B	Firmed	-	12/17/18	3 Ea	0 Ea	3 Ea	\$625.00/Ea	\$1,875.00
Line Item Note SIOP ORDER 7393 22 Jan 2018													
14	185407	RBW6205G08451-3GP			Puller Bolt Removal REV 2B	Firmed	-	12/17/18	3 Ea	0 Ea	3 Ea	\$625.00/Ea	\$1,875.00
Line Item Note SUB ASSEMBLY OF RBW6205G00331-3G 3X DEC 17 2018 ORDER 7393 22 Jan 2018													
15	185423	RBW6205G08031-3GP			Main Rotor Flanged Bushing Removal Tool REV 2	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$1,125.00/Ea	\$1,125.00
Line Item Note SUB ASSEMBLY OF RBW6205G00331-3G 1X DEC 17 2018 ORDER 7393 22 Jan 2018													
16	185424	RBW6205G08131-3GP			Main Rotor Flanged Bushing Install Tool REV 2	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$1,125.00/Ea	\$1,125.00
Line Item Note SUB ASSY FOR RBW6205G06231-3G 1X DEC 17 2018 ORDER 7393 22 Jan 2018													
17	185429	RBW6405G08832-3GP			Tail Rotor Bushing Install Tool As Per Dwg RBW6405G08832-3G Rev/D	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$875.00/Ea	\$875.00
Line Item Note SUB ASSY FOR RBW6405G08832-3G ORDER 7393 06 Jan 2019													

Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 Canada

Shipment No: 24409
Shipment Date: 18-Dec-2018
Ship Via: Pick up at METEC
Order Number: 3096
Order Date: 10/17/18

Customer Code: DART
Phone: (613) 632-9577
PO Number: PO041367 ✓
Terms: Net 60 Days

----- Quantity -----										
<u>Item</u>	<u>Open</u>	<u>Shipped</u>	<u>B/O</u>	<u>Canceled</u>	<u>Unit</u>	<u>Description</u>	<u>Revision</u>	<u>Job Number</u>		
12	2	2 ✓	0	0	EA	DART-RBW109-3101-58-2P Hammer, Aluminum, Blade Corrosion and Voids Detection	3	3096-12		DAS 38 9-89
13	1	1 ✓	0	0	EA	DART-RBW109-3101-58-1P Hammer, Steel, Blade Corrosion and Voids Detection	3	3096-13		

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Received In Good Order By



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev.#	P.O. Number
2 ✓	DART-RBW109-3101-58- 2P ✓	Hammer, Aluminum, Blade Corrosion and Voids Detection	3	41367 ✓
1 ✓	DART-RBW109-3101-58- 1P ✓	Hammer, Steel, Blade Corrosion and Voids Detection	3	41367 ✓

DAS
38
9-89

MATERIAL: supplied by METEC

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

George Theoret

Vankleek Hill, December 18, 2018

